

Date: Tuesday, 04/07/2006 2:00:44 PM
 User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: STEP SPACER
Job Number	: 27756D		
Estimate Number	: 10356		
P.O. Number	: N/A	Part Number	: D2279
This Issue	: 04/07/2006 S.O. No. : N/A	Drawing Number	: D2279 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 28/06/2006 Type : SMALL /MED FAB	Drawing Revision	: D
Previous Run	: 25395D	Material	: N/A
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 12/07/2006
Checked & Approved By	: <u>[Signature]</u>	Qty:	20 Um: Each
Comment	: Est Rev: A New Issue 05-11-07 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 0.1544 sf(s)/Unit Total: 3.0870 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2279
 Batch: m10/4/7 06 07 13

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr

m.f. 06/07/19 (20)

Date: Tuesday, 04/07/2006 2:00:44 PM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 27756D

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form As per Dwg D2279

SB 06/07/20 (20)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06.07.20 (20)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06/07/20

20

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

SB 06/07/21 20

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: GA

SAD 06/07/21

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/08/01

Job Completion



C206108101

Date: Wednesday, 6/28/2006 4:18:37 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : STEP SPACER
Job Number : 27756D	
Estimate Number : 10356	
P.O. Number :	Part Number : D2279
This Issue : 6/28/2006 S.O. No. :	Drawing Number : D2279 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL / MED FAB	Drawing Revision : D
Previous Run : 25395D	Material :
Written By :	Due Date : 7/12/2006 Qty: 20 Um: Each
Checked & Approved By : <u>KG 06 06 29</u>	
Comment : Est Rev: A New Issue 05-11-07 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	M2024T3S040	2024-T3 .040 sheet
-----	-------------	--------------------



Comment: Qty.: 0.1544 sf(s)/Unit Total : 3.0870 sf(s)
 Material: 2024-T3 sheet (QQ-A-250/4) 0.040" Thick
 (M2024T3S.040)
 Identify as D2279
 Batch: M101417

ML 07 13

2.0	SHEAR	SHEAR
-----	-------	-------



N/A



Comment: SHEAR
 Cut blanks: (4.70" x 4.50") -0.00/+0.020" (grain along 4.50")

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Waterjet

Dwg Rev: D

Fig Rev: D



ML 07 13 (20)

Comment: HAAS CNC VERTICAL MACHINING #1
 Machine as per folio D2279, use stack of 15

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ML 07 13

(20)

5.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

KG 07 10 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

Date: Wednesday, 6/28/2006 4:18:37 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP SPACER

Job Number: 27756D

Part Number: D2279

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

7.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form As per Dwg D2279

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LS Date: 06/08/01

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____

DART AEROSPACE LTD		Work Order:	27756 D
Description: Step Spacer		Part Number:	D2279
Inspection Dwg: D2279 Rev: D		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.005	0.251	✓		VERN	
2.214	+/-0.005	2.216	✓		VERN	
4.178	+/-0.005	4.178	✓		VERN	
4.428	+/-0.010	4.433	✓		VERN	
0.250	+/-0.005	0.251	✓		VERN	
1.313	+/-0.005	1.313	✓		VERN	
3.313	+/-0.005	3.314	✓		VERN	
4.625	+/-0.010	4.627	✓		VERN	
Ø0.128	+0.005/-0.000	0.128	✓		VERN	
Ø1.250	+0.005/-0.000	1.250	✓		VERN	
R0.125	+/-0.010	R0.125	✓		VERN	

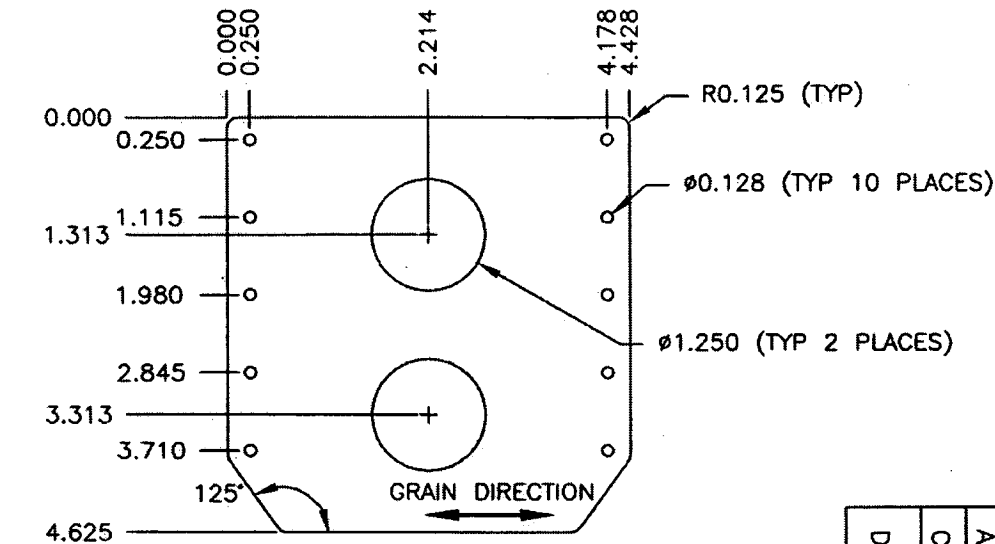
Measured by:	M. W.	Audited by:	[Signature]	Prototype Approval:	N/A
Date:	26 07 13	Date:	26 07 13	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.10.12	New Issue	P/O D2582 KJ/JLM	[Signature]

DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. D
RM	CP		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
KE	MP	D2279	
DATE	TITLE	SCALE	
98.10.05	STEP SPACER	1:2	
A	C	D	
94.10.13	94.11.15	98.10.05	
NEW ISSUE	0.588 WAS 1.607 AND 3.861 WAS 4.881	4.428 WAS 4.460, 0.040 WAS 0.032	
		CHANGES PER TSR A912	

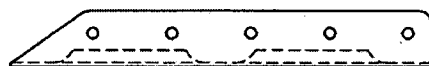


FLAT LAYOUT

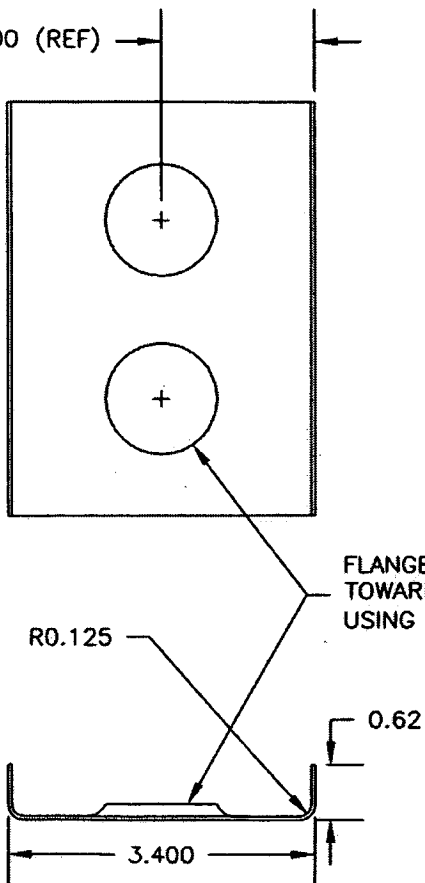
RELEASED
98.10.08 DS

UNDER REVIEW

98.02.15 CP
DESIGN OK, BUT CHECK WITH
TS BEFORE MANUFACTURE
OK 09/11/98



FLANGE AFTER BENDING
TOWARDS INSIDE OF PART
USING DT8174 (2 PLACES)



MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
TOLERANCES PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
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